

Work Order ID 152676

Friday, November 04, 2016 10:56:14 AM

152676

Page 1

Item ID: D4039-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Bracket
Start Date: 11/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/16/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: em Date: 16/11/14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4039	<u>em C</u>								
100		0.00							

100

Waterjet

Memo

FLOW CNC Waterjet

Cut blank as per file D4039-3_BLANK

110

110

HAAS 1

Memo

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA882 AND DWG

FOLIO REV: AADWG REV: C

DEBURR

Prog. Batch No. 152676
Double check by DFC

DFC
16/11/18

① de 16/11/11

1 0 DAS 20 16-11-19
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

1

Customer:

Required Date: 11/16/2016 **Req'd Qty:** 1.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS
20
9-89 16-11-19

Pro

130

0,00

130

QC

Memo

0.00

Quality Control

DA 16-11-20

DAS
08
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing



PRO
 2017/01/25
 BEB

DQA: Ant Date: 2017-02-16

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed DM Date: FEB - 7 2017Work Order update only ☐

Work Order: <u>152676</u> Part No. <u>D4039-3</u> NCR No. <u>17-6267</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
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Date: <u>17-01-24</u>	Step #: <u>140</u>	QTY Effective: <u>D</u>	MRB (QSI042) Approval DAS 9 9-89 17-01-24																																																																																																																																	
Description Work Order Deviation Small marking was found on part left for bolt imprint. R.C. was use for test fit		Disposition buff out imperfection using buffing pad and cont continue on seq. 140		Completed By BEB 17-01-24 Lead hand / Supervisor Approval Verification DAS 9 9-89 17-01-24 QC / QA Coordinator Approval DAS 9 9-89 17-01-24																																																																																																																																
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Work Order ID 152676

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152676

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Item ID: D4039-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Bracket
Start Date: 11/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/16/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>NIBB.</i> Memo	0.00 0.00		<i>START: 10:05. O.U.T: 300° FINISH: 10:35.</i>		<i>1</i>	<i>0</i>	<i>17-01-25</i>	<i>338</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>			<i>DAS 38 9-89</i> <i>JAN 25 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>JN77</i> Memo	0.00 0.00				<i>1</i>			<i>DAS 6 9-89</i> <i>JAN 31 2017</i>



Work Order update only ☐

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part No. _____			Rework ☐			Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____			Scrap ☐			Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
			Use-as-is ☐			Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
			Suspected Unapproved ☐			Large Fab ☐		Composite ☐		Supplier ☐			
Date :			Step #:			QTY Effective :						MRB (QSI042) Approval	
Description Work Order Deviation						Disposition							
												Completed By	
												Lead hand / Supervisor Approval Verification	
												QC / QA Coordinator Approval	
Root Cause			FAULT CATEGORY										
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong			
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions			
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Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence			
Past Expiry Date ☐	☐	Manufacturing Process											
Misidentified ☐	☐	Past Due	OTHER :										

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mf
17-1-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 152676

152676

Parent Item: D4039-3

D4039-3

Parent Item Name: Aft Bracket

Start Date: 11/4/2016

Required Date: 11/16/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased		No		100	f	3.0000	3	3.157895			

M6061T6B1 000X15 000

6061-T6 Bar 1.00 x 15.00

see 11/11/11

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT	3	
	m132360	2	
	m132773	1	
	134627		
			3.2

M6061T6B1.000X15.000
M134627

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

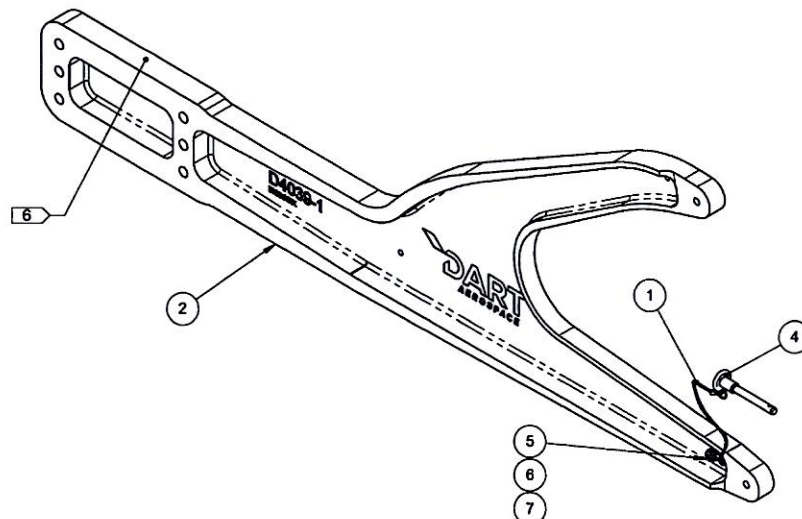
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
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OTHER : ☐					

DART AEROSPACE LTD		Work Order:	152676
Description: Fwd Bracket		Part Number:	D4039-3
Inspection Dwg: D4039	Rev: B		Page 1 of 1

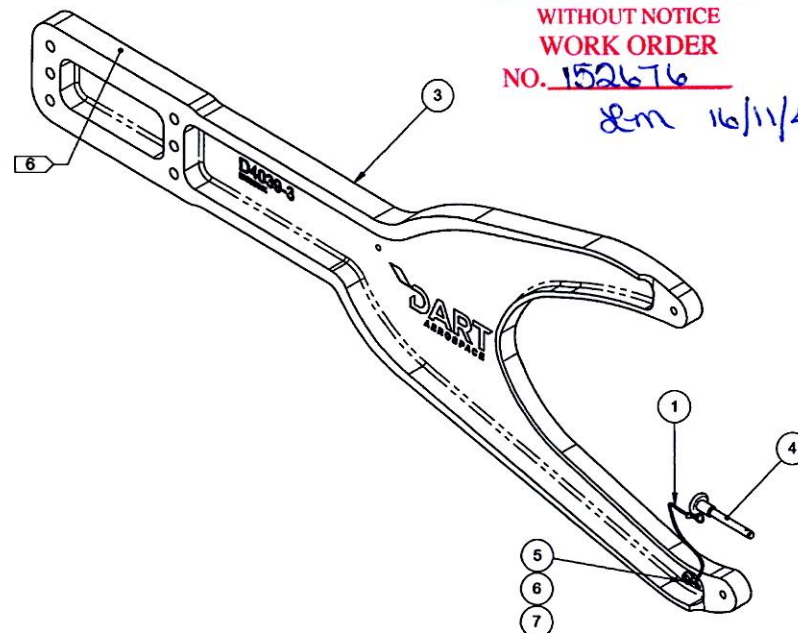
[illegible]

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.06.21	Dimensions updated per Dwg Rev B	KJ	
C	12.06.21	Dimension 0.857 revised	KJ	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4039-041	FWD BRACKET ASSEMBLY
		X	D4039-043	AFT BRACKET ASSEMBLY
1	1	1	D2690-6	LANYARD
2	1		D4039-1	FWD BRACKET
3		1	D4039-3	AFT BRACKET
4	1	1	MS17984-C416	PIN, QUICK RELEASE
5	1	1	MS27039-1-11	SCREW, PAN-HEAD
6	1	1	MS21042L3	NUT, SELF-LOCKING
7	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. 152676

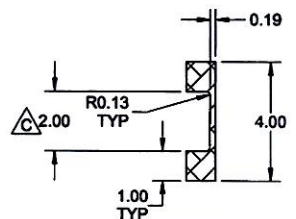
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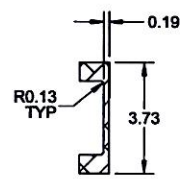
2016 NOV 02
En 16-513 9

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: N/A

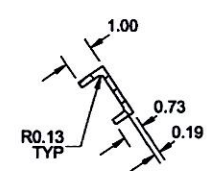
C	REVISE DESIGN OF -1 AND -3 BRACKETS; ZN C4-2, B4-2, C4-3, B4-3, REVISE NOTES 7 AND 8; A5-2, A5-3, B5-1	VS	15.11.05
B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B5-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4039	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	15.11.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



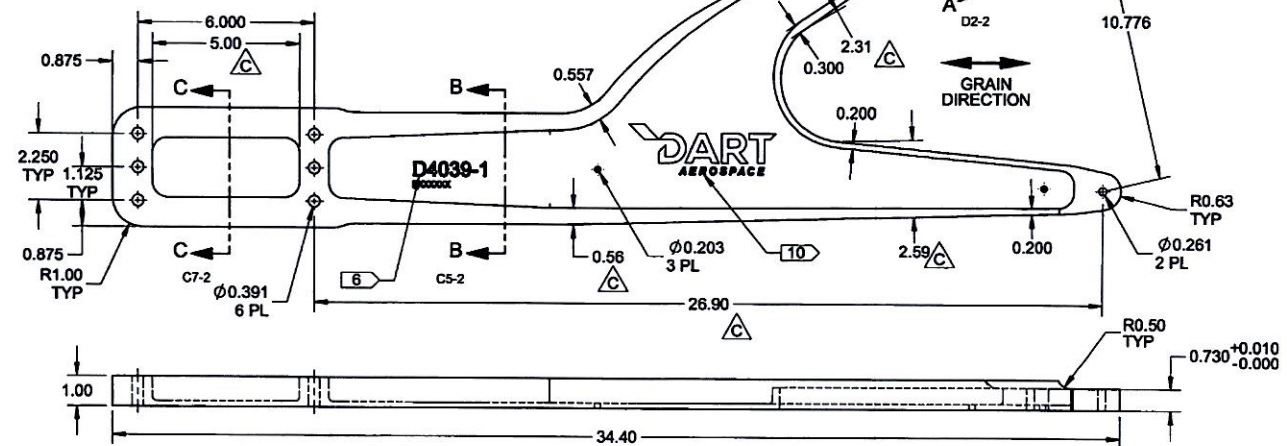
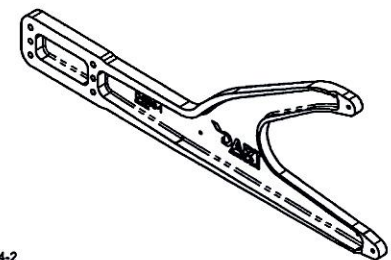
SECTION C-C
B7-2



SECTION B-B
B6-2



SECTION A-A
C4-2

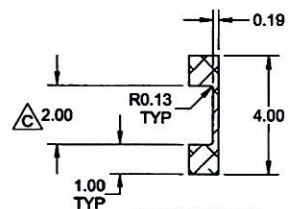


D4039-1 FWD BRACKET

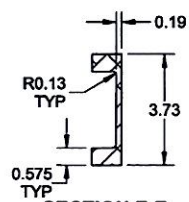
- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
 - 7) WEIGHT: 6.60 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
 - 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
 - 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

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2016 NOV 02

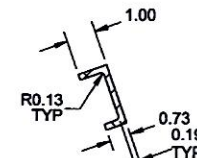
APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4039	SHEET 2 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BRACKET	NTS
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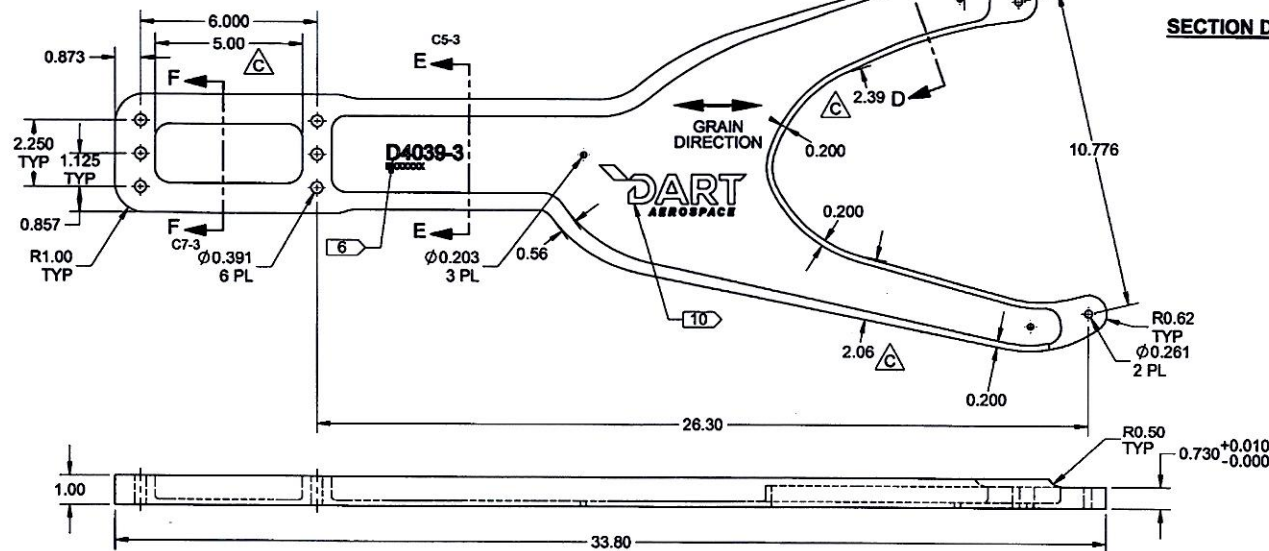
SECTION F-F
C7-3



SECTION E-E
C6-3



SECTION D-D
C4-3



D4039-3 AFT BRACKET

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2016 NOV 02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.40 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. C
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. C
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.11.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. C
D4039	SHEET 3 OF 3
TITLE	SCALE
BRACKET	NTS

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